

Work Order ID 60747

July 22, 2010 7:40:54 AM



Page 1

Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Stop



Start Date: 7/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/10 Req'd Qty: 1.00



Customer:

Reference:

W

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPPD350-607-043A CHG001

0.00

S 10/07/12

HJ for BG 10/07/22

110

0.00



Packaging

Packaging

Pick Kit

Memo

PULL FROM STOCK
1 X D350-607-043 B *60388*

0.00

S 10/07/21

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D350-607-043/ 044	CHG	CHG005
DESC	Heli-Utility-Basket	S/C	SH94-14
LOT	B60388	S/C	SR00213NY
MODEL	AS350/355	S/C	
MADE IN CANADA		D2729-1	

120

0.00



Small Fab

Small Fab

Small Fab

Memo

REMOVE PROP ARM D2332-041

AW970-x

0.00

*B 57741
M 112991*

S 10/07/21

(1)

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Item ID: D350-607-043A

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 7/22/10 Start Qty: 1.00

Cust Item ID:

Required Date: 7/22/10 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
121		0.00							
									
Large Fab									
Large Fab	Memo	0.00							
	GRIND FLUSH D2327-3 BUSHING								
	TRIM STEEL MESH LOCALLY A/R								
	TRANSFER DRILL 2 X 0.194 HOLES THRU BASKET LID SQUARE TUBE								
	AND 2 X 0.194 HOLES THRU BASKET BASE SQUARE TUBE PER DETAIL								
	S								
122		0.00							
									
HandFinish									
Hand Finishing	Memo	0.00							
	TOUCH UP PAINT A/R								
123	QC3- Inspect Part Finish	0.00							
									
QC	Memo	0.00							
Quality Control									

Cpl 10.07.22

ml 10 07 22

(70)

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Page 3

Item ID: D350-607-043A

Accept

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 7/22/10

Start Qty: 1.00

Required Date: 7/22/10

Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/12/12

①

131



Small Fab

Small Fab

Memo
RE-ASSEMBLE AS PER DRWG D350-607 TO MAKE D350-607-043A
PER ICA PG 17-18

0.00

0.00

S 10/27/12

①

132



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/27/12

①

Work Order ID 60747

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Page 4

Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 7/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Packaging	Pick Kit	0.00							
	Memo ENSURE ORIGINAL KIT IN BOX	0.00		MAS					
150 QC	QC4- 100% Inspect kits for completeness	0.00		8/10/12/22					
	Memo	0.00							
160 Packaging	Packaging	0.00							
	Memo Identify and pack for shipping as per PPP D350-607-043A USING NEW B/N	0.00							

NEW-A

Ⓢ

6/12/23

Work Order ID 60747

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Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 7/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/23

U 10-07.23

Picklist Print

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Page 1

Work Order ID: 60747

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 7/22/10

Required Date: 7/22/10

Start Qty: 1.00

Required Qty: 1.00

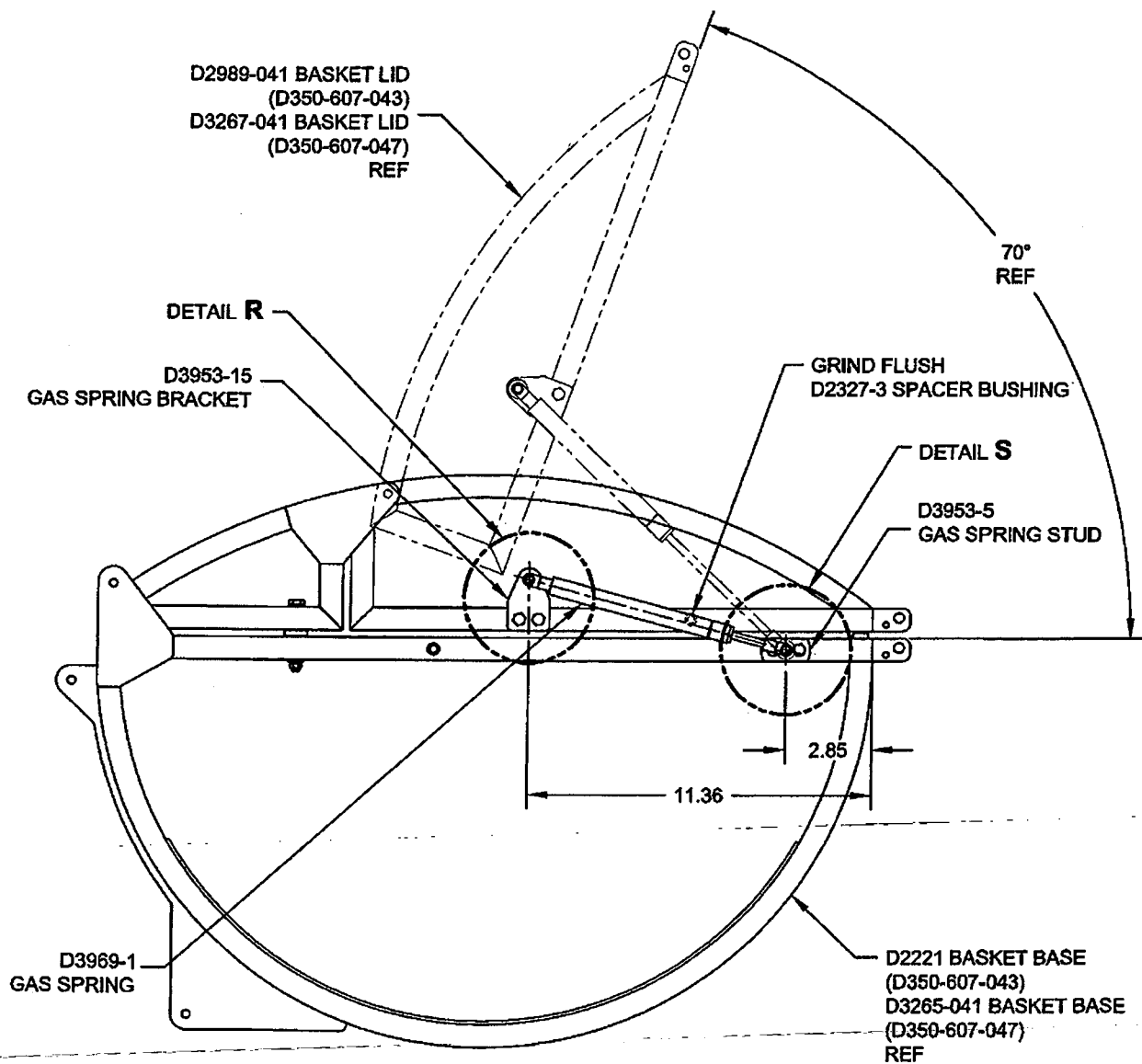
Comments: IPP RevB: as per dwg revC DD 10.01.18 verified by:EC IPP RevC: as per dwg revC DD 10.01.18 verified by:EC IPP rev:D as per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-607-043 Heli-Utility-Basket	CH705	Manufactured	No				Each	1.0000		1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		1							
					39328	1							
D350-607-143 Automatic Lid Opener Installation	CH701	Manufactured	No			110	Each	1.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG032		1							
					59705	1							

B60388 Sn 10/27/21

Sn 10/27/21

7/



D350-607-143 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

Figure 9a – Automatic Lid Opener Installation

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Revision: **A**

Date: 10.03.10

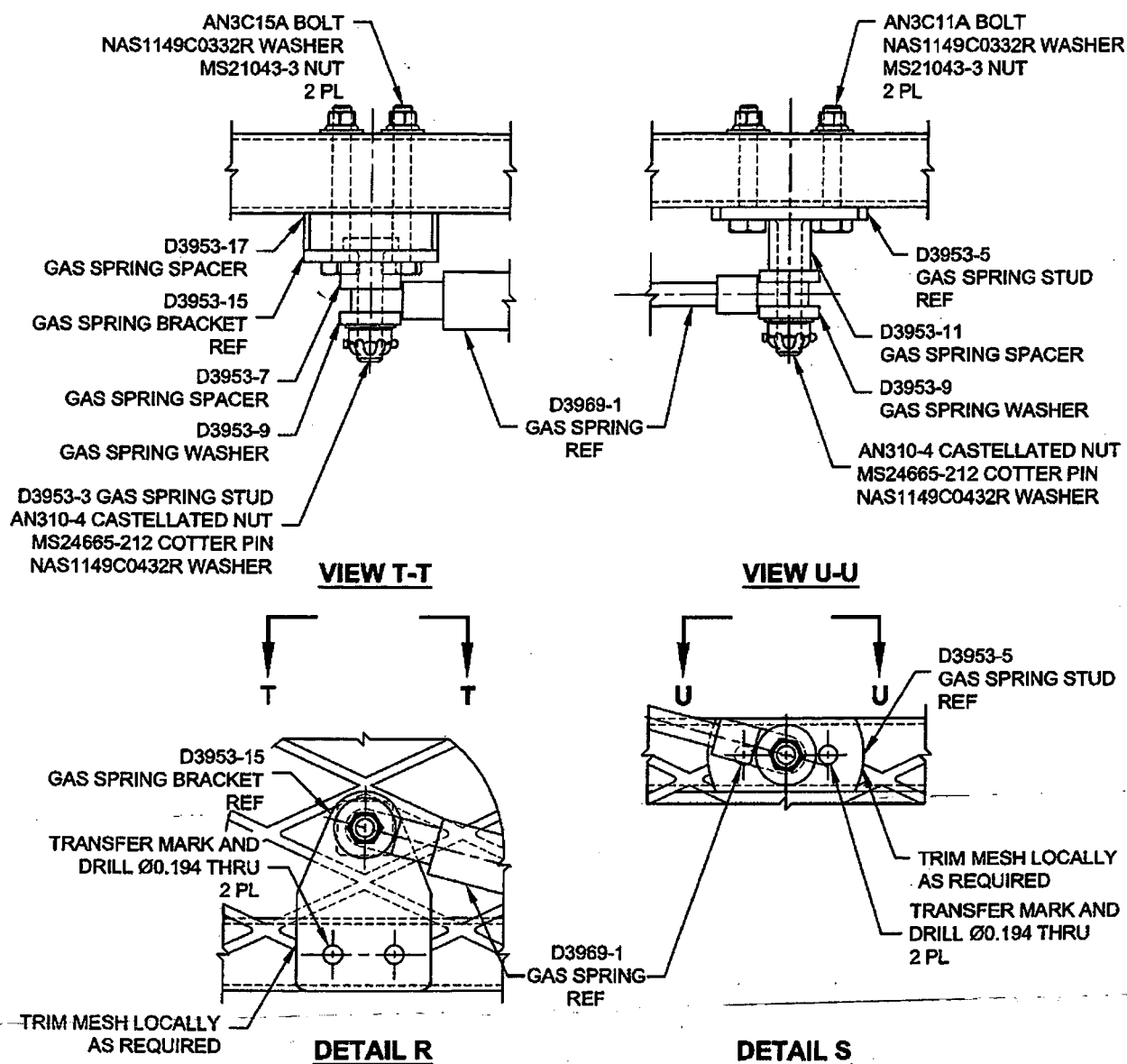


Figure 9b – Automatic Lid Opener Installation

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Revision: A
Date: 10.03.10

- 4.1.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer Mark and Drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.1.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and Fasten in Place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 chapter 7-127.
- 4.1.6. Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & Insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as Shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin Per MS33540 or AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.1.7. Repeat steps 4.1.2 through 4.1.6 at the other end of the Basket.
- 4.1.8. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.2 D350-607-143 AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)

NOTE: This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.2.1 Remove the D2332-041 Prop Arm.
- 4.2.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 9a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.2.3 Locate the D3953-15 Gas Spring Bracket as shown in Figure 9a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket Lid Square tube structure as shown in Detail R. Install the D3953-15 Gas Spring Bracket & D3953-17 Gas Spring Spacer using 2X AN3C15A BOLT, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View T-T.
- 4.2.4 Locate the D3953-5 Gas Spring Stud as shown in Figure 9a. Trim Steel Mesh Locally as required. Touch up paint per ICA-D350-607 Sections 5.1 Item 4. Transfer mark and drill 2X Ø 0.194 holes thru the Basket Base square tube structure as shown in Detail S. Install 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View U-U. Install the rod end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud using 1X D3953-9 Gas Spring washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View U-U. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.2.5 Insert the D3953-3 Gas Spring Stud into the D3953-15 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring Stud as shown in View T-T. Raise the Basket lid and install the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View T-T. Install Cotter Pin per MS33540 OR AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.

- 4.2.6 Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.3 D350-607-145 AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)

NOTE: This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.3.1 Remove the D2332-041 Prop Arm.
- 4.3.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 8a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.3.3 Locate the D3953-1 Gas Spring Bracket as shown in Figure 8a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket lid square tube structure as shown in Detail M. Install the D3953-1 Gas Spring Bracket & D3953-13 Gas Spring Spacer using 2X AN3C16A Bolt, 2X NAS1149C0332R washer & 2X MS21043-3 Nut as shown in View P-P.
- 4.3.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.3.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.3.6 Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- NOTE:** The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.3.7. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.4 D350-607-241 BASKET CLAMP KIT INSTALLATION

Refer to Section 3.0 of these instructions to install the D350-607-241 Basket Clamp Kit.
Amend weight and balance accordingly per Section 5.0 of these instructions for each D350-607-241 Kit installed on the aircraft.